



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4634-143
Job Sheet 167077-D



Part No: D4634-143

Job Qty: 1 ea

Part Name: Middle, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	2017-12-14 250
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	17/12-19 250
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	2017-12-19 250
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	DEC 21 2017
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-143 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 10/01/27 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	- D4634-3 5021664	1	2	0	0
	- D4636-5 5021663	2	43	0	0
	- D4647-1 5021662	1	4	0	0
	- D4664-5 5021661	6	39	0	0
	- D4712-1 5021660	2	4	0	0
	- D4732-21 5021659	1	6	0	0
	- D4732-25 5021658	1	7	0	0
	- D5021-3 5021657	1	2	0	0
	- MPNY-750S-9-C 5021656	3	570	0	0
	- MS20426AD3-4 5021655	4	5,055	0	0
	- MS20426AD4-6 5021654	4	2,797	0	0
	- MS21059L08 5021653	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date: _____		DISPOSITION Rework ☐ Scrap ☐		AGAINST DEPARTMENT/PROCESS			
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		D4634 - 143 Start up Operation Mfg Date: 12/14/17 Job No: 167077 - D		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
				QTY Effective : _____			
				Disposition			
				Completed By _____			
Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified		PART NO: Revision: Operation: Change No:		MRB (QS1042) Approval			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
				FAULT CATEGORY			
				Temperature/Cure ☐ Set-up ☐ OM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Muntersink ☐ Part Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	